

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003372**Date Inspected:** 21-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Han jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Vatcher, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following: The weather today is 27C and clear.

**Orthotropic Box Girder (OBG) Fabrication**

QA performed ultrasonic testing (UT) in tower shop bay 8 on the following 30 mm to 12 mm Orthotropic Box Girder Floor Beam piece marks to support the QA non destructive testing per the contract documents for contractor compliance. FB-002-007-026, FB008-007-026, FB008-008-026, FB015-016-026 and FB015-015-026. Please see the UT report TL-27 generated on this date.

QA also performed a cursory review of the welding techniques while in OBG Bay 8 FB042-001-032. QA observed QC representatives Han jie & Tang You Qing perform amp, volt and travel speed measurements for the 30mm to 12mm full penetration joint. QC also pointed out the between inner weld passes that one 2 mm diameter porosity indication was noted at the start/ stop juncture at the termination point of the weldment. QC directed the welding assistants to grind said indication out prior to further subsequent weld layers.

The above mentioned items as observed by QA appear to be in conformance with the contract documents.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

### Summary of Conversations:

No relevant conversations this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Vatcher,Robert
----------------------	----------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Cuellar,Robert
---------------------	----------------

QA Reviewer
-------------